

Date: Wednesday, 12/14/2005 4:03:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET HINGE
Job Number : 25239	
Estimate Number : 10588	
P.O. Number : N/A	Part Number : D22323
This Issue : 12/14/2005 S.O. No. : N/A	Drawing Number : D2232 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 24527	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/10/2006
Checked & Approved By : <u>SEE COMMENT BELOW</u>	Qty: 51 Um: Each
Comment : Est. B 01.06.07 Now laser cut EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 00000298

Laser cut as per DWG D2232

Material: 304/316 ss 0.125" thick

Material release note attached

2.0	D22323F	Basket Hinge
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 Basket Hinge

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

SAD 06:01:22 51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 4:03:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 25239

Part Number: D22323

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS3

CL06/01/23

(51)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/25

(51)

06/01/24

(52)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

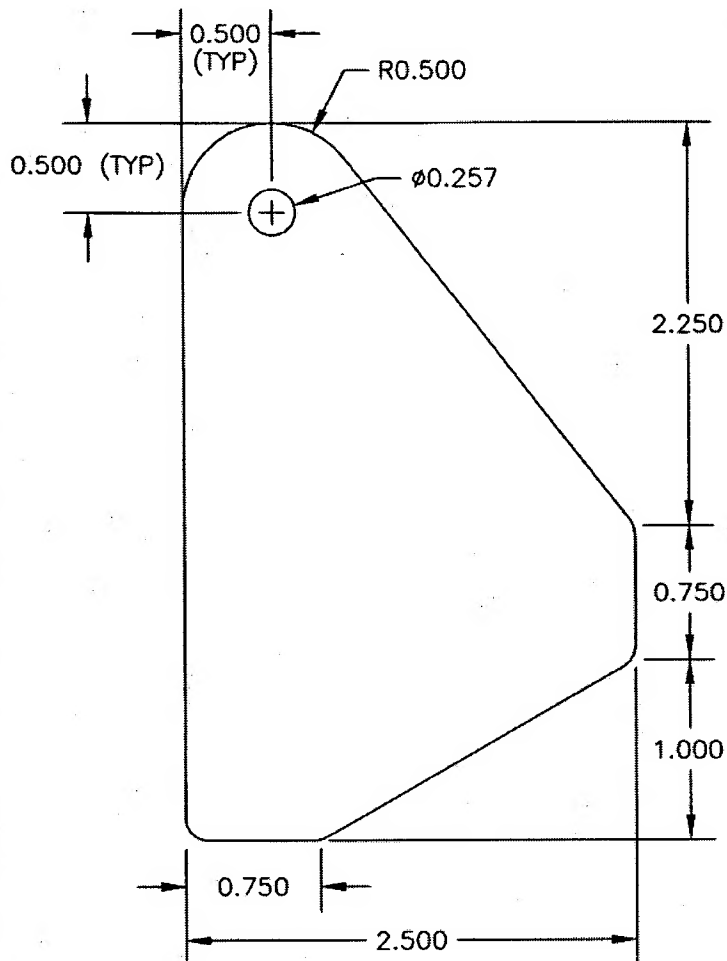
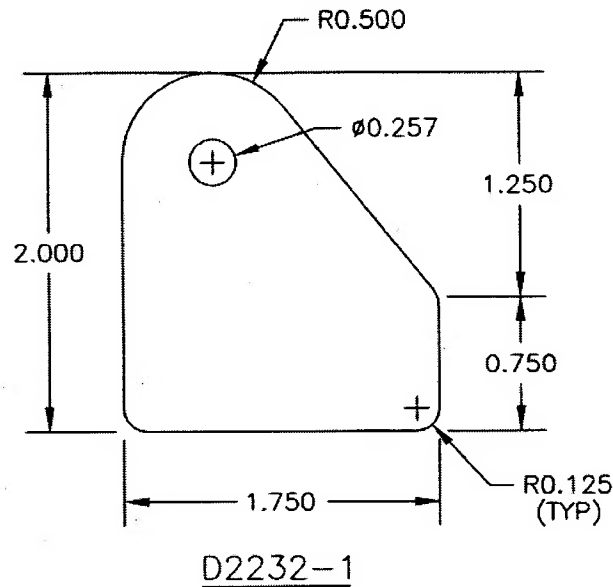
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C	
DATE		D2232	SHEET 1 OF 2	
98.04.28		TITLE	SCALE	
		BASKET HINGE	1:1	
A	94.05.12	NEW ISSUE		
B	96.01.02	ADDED -5 AND -7		
C	98.04.28	0.125 THICK WAS 0.063		



MATERIAL: AISI 304/316 SS 0.125 THICK

NOT COPY
RETURN TO
ENGINEERING
DART AEROSPACE LTD CO.

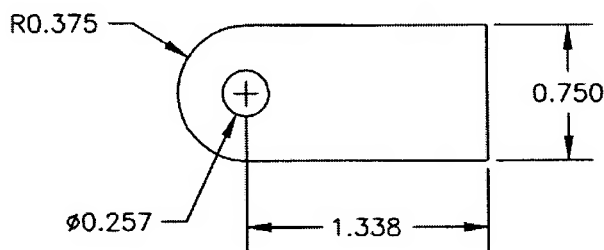
25239

DART

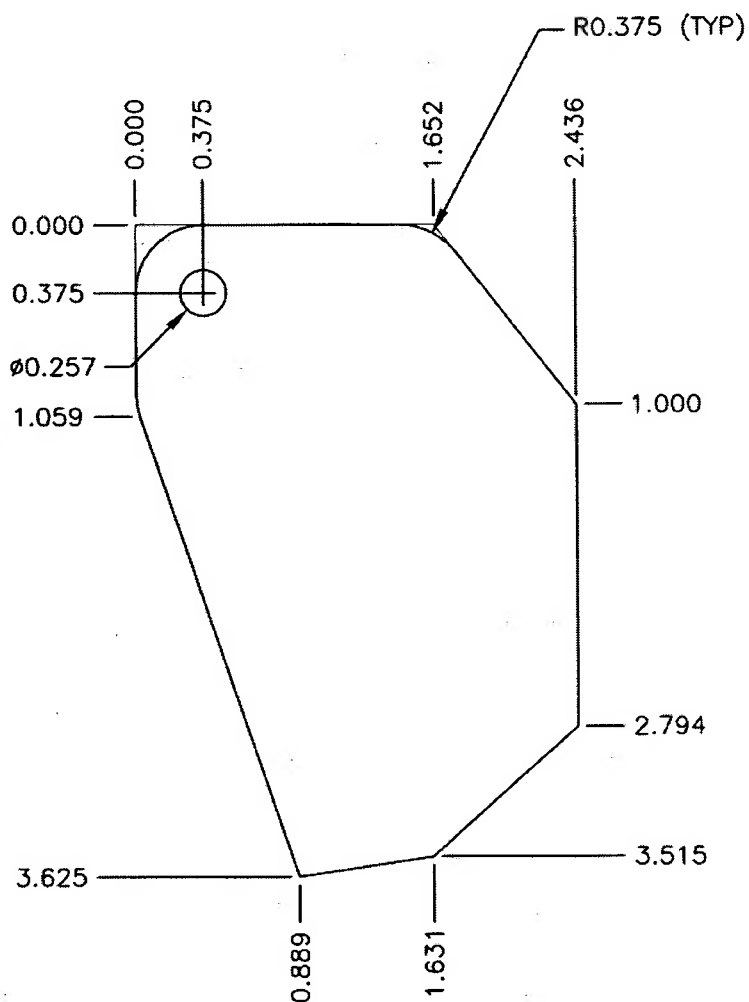


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2232
DATE		SHEET 2 OF 2
98.04.28		SCALE 1:1
		TITLE BASKET HINGE

RELEASED
48.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

ADP
252239

SPECIFICATION :
CUSTOMER :

AISI 304
INTEGRIS METALS LTD

SIZE	BUYER'S ITEM NUMBER	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 mm					Chemical Composition (%)							
							Y.S.	T.S.	EL.	HRB	HV	C	Si	Mn	P	S	Ni	Cr	N
			KGS	LBS			(N/mm ²)	(N/mm ²)	(%)			x100	x100	x100	x1000	x1000	x100	x100	x100
AISI 304 2B																			
11GA / 48" X 120"	(7427-6445)	1	1,404	3,095	YU136029	42S56953A-2122	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4
11GA / 48" X 120"	(7427-6445)	1	1,051	2,317	YU136029	42S56953A-2123	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4
11GA / 48" X 96"	(7427-6403)	1	1,398	3,082	YU136785	42S60093B-11	290	659	51	84	169	4.3	47	119	28	9	809	1827	2.9
AISI 304 NO.4																			
16GA / 36" X 120"	(7426-6064)	1	1,396	3,078	YU282630	41S56329-22111	300	670	50	82	159	4.7	50	122	25	9	805	1813	2.9

Remarks:
NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Bend test: good for all Heat NO.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262E, ASME SA240, QQS766D.
P.O. NO.: 494470

YIEH MAU CORP.

Manager of Quality Assurance Section

11 ga 304 2B ss

06-01-17

186, 215, 146, 298, 245